

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER :							
Misidentified ☐	Past Due ☐								

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Quality Control

NOV 23 2011

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	Chemical Conversion Coat per QSI005 4.1	0.00							
150						(X8)	Ø		2016/11/11
HandFinish	Memo	0.09							BE
Hand Finishing									
155	QC7-Inspect Chemical Conversion Coat	0.00							
155						8	Ø	16-11-24	DAS 34 9-89
QC	Memo	0.01							
Quality Control									
160	Black Sandtex(Ref:4.3.5.7) per QSI005 4.3	0.00							
160	m 129777								
Powdercoat	Memo	0.04							
Powder Coating	START TIME: 2:15 FINISH TIME: 2:45								
	OVEN TEMPERATURE:								
						8	Ø	16-11-24	DAS 34 9-89

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Work Order ID 152755

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152755

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Item ID: D2344 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Deck Plate Aft
Start Date: 11/1/2016 Start Qty: 8.00 ***8*** Cust Item ID:
Required Date: 11/7/2016 Req'd Qty: 8.00 ***8*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170 *170* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.01				8			DAS 38 9-89 NOV 25 2016
180 *180* Packaging Packaging	Identify as per dwg & Stock Location: <u>Stops</u> Memo	0.00 0.01				8			NOV 25 2016 DAS 6 9-89 68-6 350
190 *190* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.13							16/11/28 JF DAS 21 9-89 NOV 25 2016

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Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐			FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐		
OTHER : ☐					

Picklist Print

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Page 1

Work Order ID: 152755

152755

Parent Item: D2344

D2344

Parent Item Name: Deck Plate Aft

Start Date: 11/1/2016

Required Date: 11/7/2016

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP Rev:D00.06.26Removed P/O for powder coatEC
IPP Rev:E 07-07-04 Asper Rev F JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S.063		Purchased		No		100	sf	153.5000	0.745	6.273684			
M2024T3S 063									**			11/11/19	
2024-T3 .063 sheet													

Location

Loc Qty

Loc Code

MAT

33.8

m135512

33.8

MAT009

119.7

m134640

62.1

m135612

57.6

6.8

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OTHER :					

DART AEROSPACE LTD		Work Order:	152785
Description: Litter Deck Plate Kit (350)		Part Number:	D2344
Inspection Dwg: D2344 Rev: F		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ **First Article**

 ☐ **Prototype**

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
6.223	+/-0.010	6.229	'		Visual	
5.598	+/-0.010	5.599	'		Tap	
4.869	+/-0.010	4.871	'			
3.889	+/-0.010	3.891	'			
3.096	+/-0.010	3.099	'			
2.891	+/-0.010	2.894	'			
16.973	+/-0.010	16.973	'			
0.450	+/-0.010	.454	'			
4.423	+/-0.010	4.422	'			
4.723	+/-0.010	4.722	'			
1.202	+/-0.010	1.203	'			
5.869	+/-0.010	5.871	'			
4.654	+/-0.010	4.658	'			
Ø0.656	+0.005/-0.000	Ø.655	'			
1.888	+/-0.010	1.888	'			
2.285	+/-0.010	2.282	'			
2.683	+/-0.010	2.684	'			
Ø0.171	+0.005/-0.000	Ø.170	'			
3.491	+/-0.010	3.497	'			
Ø0.191	+0.005/-0.000	Ø.190	'			
3.123	+/-0.010	3.126	'			
1.975	+/-0.010	1.979	'			
Ø0.128	+0.005/-0.001	Ø.127	'			

Measured by:	<i>me</i>	Audited by:	DAS 38	Prototype Approval:	N/A
Date:	16/11/19	Date:	NOV 21 2019	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.06.25	New Issue P/O D350-616-015	KJ/JLM	
B	07.07.17	Dwg Rev. updated	KJ/JLM	
C	07.09.06	Dimensions updated per Dwg. Rev. F	KJ/JLM	<i>EF</i>

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